PRODUCT BULLETIN GYPSUM PRODUCTS	GYPSUM VENEER BASE TYPE X SUPER ½" x 48" WIDE FOR VENEER PLASTER	BULLETIN NO: B-15D DATE: 6-3-75 PAGE: 1 of 4
APPROVALS:	ASTM C588	CANCELS: B-15D DATE: 1-15-69

Core Formula (1bs/	MSF)	Long <u>Beach</u>	Antioch	<u>Seattle</u>	Delanco & Jacksonville
Board Stucco	(S-1, S-2)	1300~1500	1300-1500	1300-1500	1300-1500
Glass Fiber	(B-G-1)	3.8-4.2	3.8-4.2	3.8-4.2	3.8-4.2
Paper Fiber	(B-G-1)	10-12	13-15	10-12	13-15
Vermiculite Ore	(RM-B-28)	7 0 - 75	70-75	70-75	70-7 5
Starch	(B-G-1)	7-10	7-10	7-10	7-10
Dextrose	(RM-B-3)	0-3	0-3	0-3	0-3
Core Foaming Agent	•	•			
ALS AAS	(B-G-1) (B-G-1)	0.2-1.7	0.2-1.0	0,2-1.0	0.2-1.7
Lignin		none	none	none -	none
End Trim	(B-G-1)	20-35	10-30	20-35	20-35
Potassium Sulfate	(B-G-1)	9.5-2.0	0-2.0	0.5-3.0	0.5-2.0
Hydrated Lime	(B-G-1)	0-0.5	0-0.5	0-0.5	0-0.5
Retarder Rosario	(B-G-1)		0-0.5		

Paper Liners: Grade 7004 Coreboard paper for both sides. Grade 7002 Greyback paper may be used on back of 48" wide Veneer Base.

Paper shall be free from quick saturation points.

NOTE: Formula is based on U.L. Label Procedure R3543, Section 3.

PRODUCT BULLETIN GYPSUM PRODUCTS GYPSUM VENEER BASE
TYPE X SUPER
1/2" X 48" WIDE
FOR VENEER PLASTER

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CANCELS: DATE: 3-150 12/1/69

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ASTM C588

OPERATING SPECIFICATIONS: (Refer to Process Bulletin BG-2 for General Specifications)

ALL PLANTS

1. Slurry Setting Time (minutes)

2.0-4.5

2. Wet Slurry Weight

(lbs./cu.ft.)

72-82

3. Wet Compressive Strength

(psi)

235-400

- 4. <u>Liner Absorption Correction</u> Apply a 0.5 maximum percent solution of wetting agent (Bulletin RM-B14) by felt to the face of the base as required to meet the face paper absorption specification.
- 5. Use Flexograph rust orange ink (RM-B21) for face printing as shown on Page 4 of 4.

PRODUCT SPECIFICATIONS: (Refer to Product Bulletin BG-4 for General Specifications)

*	All Plants
Wet Weight (Lbs/MSF)	2800-3050
Dry Weight (Lbs/MSF)	1875-2050
Average	1950
Evaporation Loss (Lbs/MSF)	900-1100
Thickness - Average (inch)	.503 minimum
Thickness - Individual reading (inch)	+ .010 from average
Edge Hardness at take-off (lbs.)	8.0 min., 18 max., 13 average
End Peel after Sawing (inch)	1/8 maximum
Flexural Strength, minimum	
Across grain (lbs.)	150
Parallel (lbs.)	60
Deflection at Break, minimum	
Across grain (inch)	0.25
Parallel (inch)	0.15

PRODUCT BULLETIN GYPSUM PRODUCTS

GYPSUM VENEER BASE
TYPE X SUPER
1/2" X 48" WIDE
FOR VENEER PLASTER

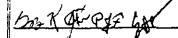
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PRODUCT SPECIFICATIONS: (Cont'd.)

	All Plants	
Punch Test (lbs.)	800-1200	
Twist Test, maximum split		
Face (inch)	3/4	
Back (inch)	3/4	
Hammer Loss, decigrams		
Individual Test, maximum	5	
Bond at High Humidity, maximum peel		
Face (inch)	1/2	
Back (inch)	1/2	
Absorption Rate, Veneer Base Face (minutes)	3-6	
Absorption Rate, Paper Bound Edges (minutes)	2-6	
Liner Spread, Veneer Base Face, 16ths of an inch	20-35	
Length Tolerance on Specified Length	1/4" under, no over	
Width Tolerance on Specified Width	3/32" under, no over.	

Edges shall be square; or, Edges of the base shall be round tapered edge. The over-all thickness on opposite edges of the base shall check to within .010". See Operating Bulletin B-C-4, page 2 and 3.

Profile - Variations in the surface of the face and back planes shall be not greater than 0.010" in a 6 inch span measured across the width.

Ends of the base shall be cut straight and clean without breaking or damaging the core at the cut.

PRODUCT BULLETIN GYPSUM PRODUCTS GYPSUM VENEER BASE TYPE X SUPER 1/2" X 48" WIDE FOR VENEER PLASTER

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PRODUCT SPECIFICATIONS: (Cont'd.)

Surface - Face shall be smooth and free from scuffed areas, blisters, or loose paper plies. Minor cockles not over 0.060" or 1/16" deep are permissible on the back surface.

Core Quality - Voids shall be small and uniform in size. Core shall contain no voids more than 1/8" in length by 1/4" in width.

1/2" TYPE X SUPER KAISER VENEER BASE FACE PRINTING SHALL READ:

(print on one

edge)

Note: DO NOT use the Null-A-Fire designation on Veneer Base.

BUNDLING - Bundle two pieces face to face with 3/4" zip tape and bundling tape designated for 4' wide Gypsum Veneer Base Type X Super. Do not use UL Label Bundling Tape.